

Work Order ID 52410

September 23, 2009 1:49:40 PM

Page 1

Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence
ID

Work
Center ID

Operation
Description

Set Up

Run

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN-D206-642

Rev M

100

DC

0.00

0.00

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP D206-642-541
CHG003

N/A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52410

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	Skidtubes	0.00	0.00							
	Skidtubes	Memo 1- Bend FWD end of tube using bend prog D3274 FWD dwg D3274, cut fwd end of tube with saw table setup D3274. 2- remove fwd indexing ridge as per dwg D3274. Prepare for welding 3- weld fwd cap as per dwg D3274 and QS1004 AR Aluminum Rod Batch: <u>M109213</u> 4- grind fwd cap weld on top surface only 5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end. 6-Drill Aft cap pilot hole using DT8025 7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D. Drill 3/16" pilot holes as per Dwg D3274 8 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe batch # 9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.									

DP 9-9-29

PD 09.09.30

DP 9-9-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

September 23, 2009 1:49:45 PM

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09 **Start Qty:** 1.00

Cust Item ID:

Required Date: 10/08/09 **Req'd Qty:** 1.00

Customer ID:

Customer Name:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

[illegible]

W/O:		WORK ORDER CHANGES					
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Req'd Qty: 1.00

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Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Skidtubes	Skidtubes	0.00	0.00							
		Memo									
		1-Open Ø0.313" and 0.375" crossbolt spacer holes using DT8743 as per Dwg D3274									
		2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from inside the tube									
		3-Bond web in place as per Dwg D3274 & QSI 015. A/R <input type="checkbox"/> Sikaflex-291 <input checked="" type="checkbox"/> <u>11/23/09</u> Sikaflex expire date: <input type="checkbox"/> <u>02/30/2010</u> Start: <input type="checkbox"/> <u>9-9-30</u> Time: <input type="checkbox"/> <u>3:30 PM</u> Finish: <input type="checkbox"/> <u>9/23/09</u> Time: <input type="checkbox"/> <u>8:40 AM</u> (Adhere for 12 hours)									
160	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control	Memo									

DP 9-9-30

2) 5/2/09

② 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52410

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Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Skidtubes	Skidtubes	0.00	0.00							
	Skidtubes										
	Memo	1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.									
		2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2 OPEN HOLES TO .297" . Deburr									
		3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD END OF TUBE DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES) REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES									
		4- Countersink crossbolt spacer holes as per Dwg D3274									
		5- prepare for welding									
180	QC	QC5- Inspect part completeness to step on W/O	0.00	0.00							
	Quality Control										
	Memo										

9-10-1

PTC

2) 808/10/01

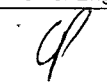




④

A2
L° = 4.8°

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D206-642-541 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: AS Date: 09.11.06

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 52410		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09.10.01	170	Aft hand height 15 3.25'	 09.10.01 pc QSI 042	Acceptable	 9-10-1	 09/10/01	 09.10.01 pc QSI 042	 09/10/01

NOTE: Date & initial all entries

September 23, 2009 1:49:56 PM

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09 **Start Qty:** 1.00

Cust Item ID:

Required Date: 10/08/09 **Req'd Qty:** 1.00

Customer ID:

Customer Name:

Approvals: **Process Plan:**

Date: _____ **Tooling:** _____

Date: _____

QC:

Date:

SPC (Y/N):

Date:

Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

September 23, 2009 1:49:57 PM

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:**Required Date:** 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:**Approvals:**

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

September 23, 2009 1:49:57 PM

Reference:

Item Name: Replacement Skidtube

Cust Item ID:

Customer ID:

Customer Name:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

270	HandFinish	0.00	0.00	21
-----	------------	------	------	----

Hand Finishing

HandFinish

0.00

0.00

 α

Memo

HAND FINISHING RESOURCE #1

1-Install wearpads & gaskets as per Dwg D3274.

2-Install ring as per Dwg D3274

A/R [] Sikaflex-291 [] m 112391

Sikaflex expire date: 10/20

3-Inspect for foreign objects as per QSI 024

4-Spray inside of tube on both sides of web with LPS-3

A/R LPS-3 Batch: *MAC*

5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.

A/R(11) Sikaflex-291 112391

Sikaflex expire date: 11/16/20

LOS PROCYON MAY 25/

MO 09110119

Memo

QC5- Inspect part completeness to step on W/O

0.00

0.00

2) 809/10/70

(A)

1

290 Packaging
Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00

pp 520 ff

Pr 9/10/21 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 52410

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Item ID: D206-642-541

Reference:

Revision ID: M

Item Name: Replacement Skidtube

Start Date: 9/23/09

Start Qty: 1.00

Cust Item ID:

Required Date: 10/08/09

Req'd Qty: 1.00

Customer ID:

Customer Name:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Hours

Sequence ID	Work Center ID	Operation Description	Set Up	Run	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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300	QC	QC21- Final Inspection - Work Order Release	0.00	0.00							
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Quality Control

Memo

09/10/22 JF

u 09.10.21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:17 PM

Page 1

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2600-1-190RevD1		Manufactured	No			110	Each	74.0000	1.0000			



Extrusion Round 3" 206

9-9-29

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

47575

74

74

D3285-1RevA

Manufactured

No

110

Each

34.0000

12.0000



Cap

1

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47635

34

34

D3282-041RevC

Manufactured

No

150

Each

10.0000

1.0000



Float Web (206L/407)

1 PD 09.09.30

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

48389

10

10

9-9-30

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 2

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2649RevB1		Manufactured	No			190	Each	711.0000	1.0000			



Cross Bolt Spacer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

628

36013

5

47112

383

48271

240

(128)

MB 09-10-01

D3275-1RevA1

Manufactured

No

190

Each

100.0000

12.0000



Crossbolt Spacer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

100

47464

1

48117

43

48270

56

(124)

MB 09-10-01

September 23, 2009 1:49:18 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 3

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

CR3212-4-03

Purchased

No

250

Each

314.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

314

111359

96

112314

200

15984

18

D3415-041RevB

Manufactured

No

250

Each

95.0000

1.0000



Nut Plate

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

95

33842

95

CCR264SS3-3

Purchased

No

250

Each

271.0000

2.0000



Cherry Rivet

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

271

111548

56

111827

115

112314

100

X2 mo 09/10/15

X1 mo 09/10/15

X2 mp 09/10/15

September 23, 2009 1:49:18 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-130		Purchased	No			250	Each	5,439.000	78.0000			



Insert

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	5439	
110511	5439	

D3536-15RevA Manufactured No



Gasket

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	43	
47711	5	
48159	12	
51600	26	

September 23, 2009 1:49:18 PM

Shop Packet Print

Page 4

112772

X98

MD 09/10/15

X1

MD 09/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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September 23, 2009 1:49:19 PM

Page 5

Work Order ID: 52410

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Comments:

Start Date: 9/23/09

Required Date: 10/08/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3536-23RevA		Manufactured	No			270	Each	32.0000	1.0000			



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

FP

12

51609

12

Main Warehouse

ST

20

30754

1

47713

19

D3536-35RevA

Manufactured

No

270

Each

41.0000

1.0000



Gasket

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

41

48160

15

51628

26

X1 MD 09/10/16

X1 MD 09/10/16

September 23, 2009 1:49:19 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3536-39RevA		Manufactured	No			270	Each	30.0000	1.0000			
												
Gasket												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

FP 12

51637 12

Main Warehouse

ST 18

44648 1

47714 6

48161 11

~~max~~ mb 09/10/16

D3535-15RevB Manufactured No

270 Each 15.0000 1.0000



Wearshoe

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 15

30750 4

42233 1

48155 10

XI mb 09/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:20 PM

Page 7

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3535-35RevB

Manufactured

No

270

Each

12.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

48157

12

D3535-39RevB

Manufactured

No

270

Each

15.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

15

47525

2

48158

13

D3535-23RevB

Manufactured

No

270

Each

13.0000

1.0000



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

48156

13

XI MD 09/10/16

XI MD 09/10/16

XI MD 09/10/16

September 23, 2009 1:49:20 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:21 PM

Page 8

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3537-3RevC

Manufactured

No

270

Each

72.0000

1.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

72

30758

8

33881

17

35697

47

D3537-1RevC

Manufactured

No

270

Each

192.0000

9.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

30

48288

2

50321

28

Main Warehouse

FP17

162

51678

162

X1 MD 09/10/16

x9 MD 09/10/16

September 23, 2009 1:49:21 PM

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Page 8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:28 PM

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L		Purchased	No			270	Each	6,864.000	80.0000			



washer

Warehouse
Location

Loc Qty

Loc Code

OFFSHORE

FG

100

103585

100

Main Warehouse

ST

6764

112116

1764

112612

5000

AN960C416

Purchased

No

270

Each

706.0000

1.0000



washer

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

706

100993

706

X80 mo 09/10/16

X1 mo 09/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:28 PM

Page 10

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3672-1RevB		Manufactured	No			270	Each	1,186.000	2.0000			



Phenolic Washer



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 686

39275 19

42329 121

47628 546

Main Warehouse

ST117 500

51674 500

~~12~~ mo 09/10/16

AN3C4A

Purchased

No

270

Each

1,976.000 80.0000



BOLT



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 1976

112082 14

112314 140

112612 146

112720 1176

112724 500

~~12~~ mo 09/10/16

September 23, 2009 1:49:29 PM

Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:34 PM

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Start Date: 9/23/09

Required Date: 10/08/09

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4C5A Purchased No 270 Each 603.0000 1.0000



BOLT

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 603

104936 19

110552 82

112243 500

18918 2

D2646RevC Manufactured No 270 Each 56.0000 1.0000



Aft Cap

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 56

20208 0

43801 1

46327 6

48109 49

~~XT~~ mp 09/10/16

XT mp 09/10/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

September 23, 2009 1:49:34 PM

Page 12

Work Order ID: 52410

Parent Item: D206-642-541RevM

Parent Item Name: Replacement Skidtube

Comments:

Start Date: 9/23/09

Required Date: 10/08/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3413-1RevA		Manufactured	No			270	Each	22.0000	1.0000			



Ring



Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 22

48123 22

XL mo 09/10/10

September 23, 2009 1:49:34 PM

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Page 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED

07.02.12

DEO ATTACHED

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3274	REV. D SHEET 1 OF 4
DATE 06.12.19		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.03.15	NEW ISSUE	
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76	
C	05.03.16	ADD -043; NEW INSERTS	
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

do
52410**GENERAL NOTES:**

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

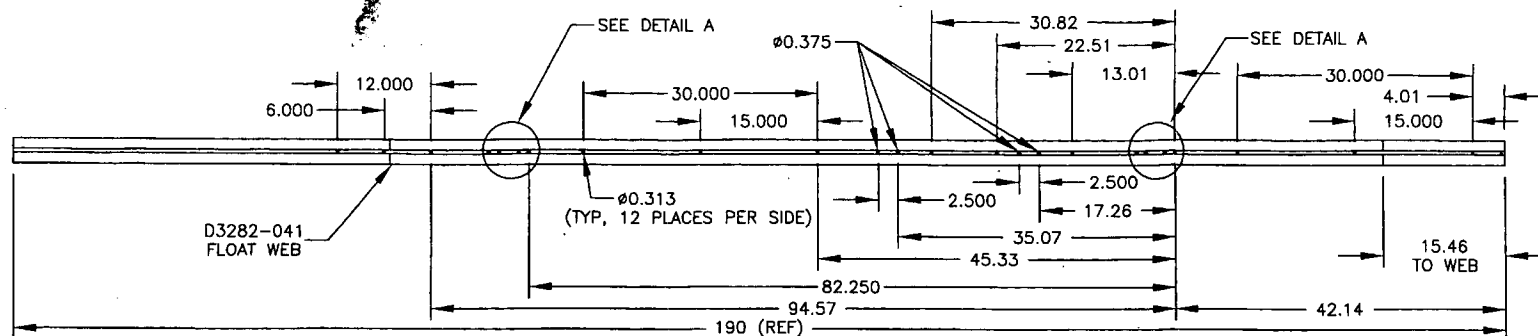
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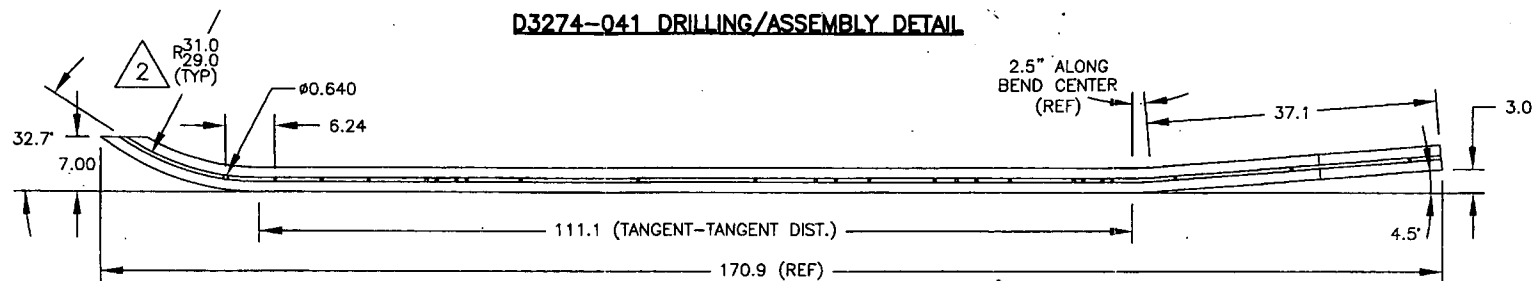
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

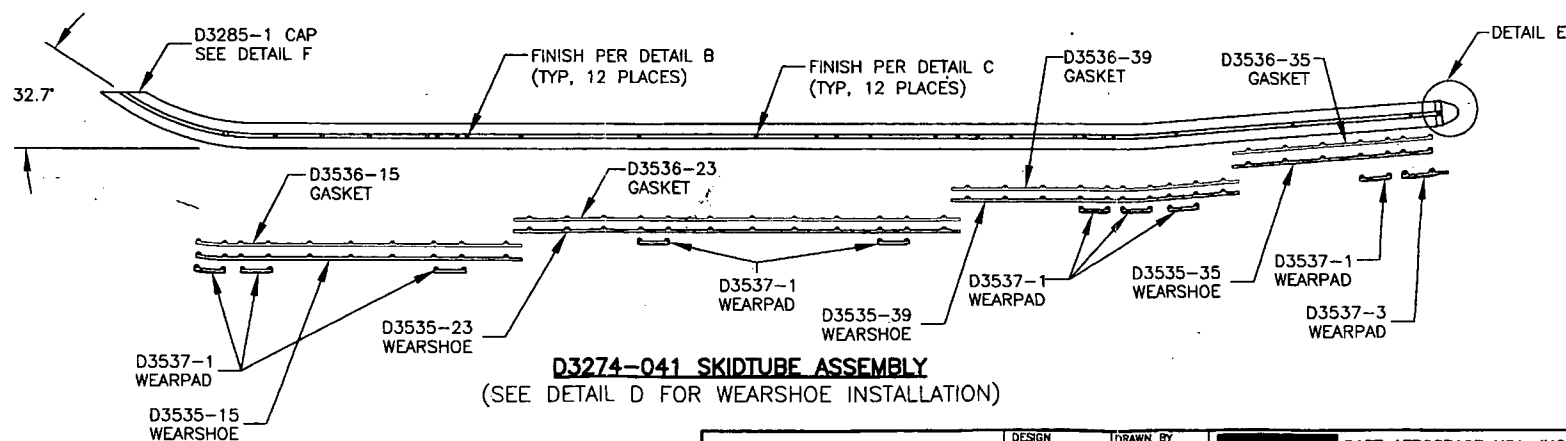
DEO ATTACHED



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC.	REV. D
CHECKED	#	APPROVED	#	DART AEROSPACE USA, INC.	PORT HADLOCK, WA
DATE	06.12.19	DRAWING NO.	D3274	SHEET 2 OF 4	SCALE
		TITLE	SKIDTUBE ASSEMBLY		1:15

SPD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

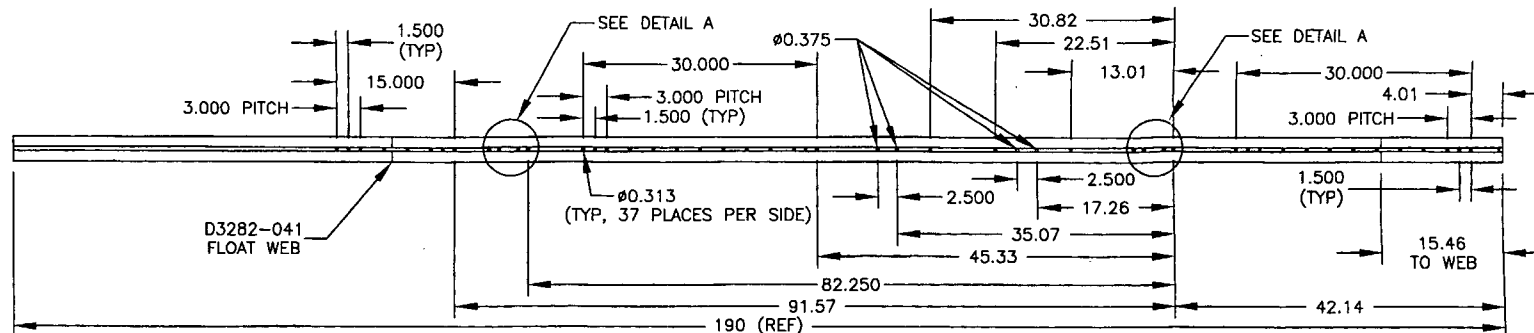
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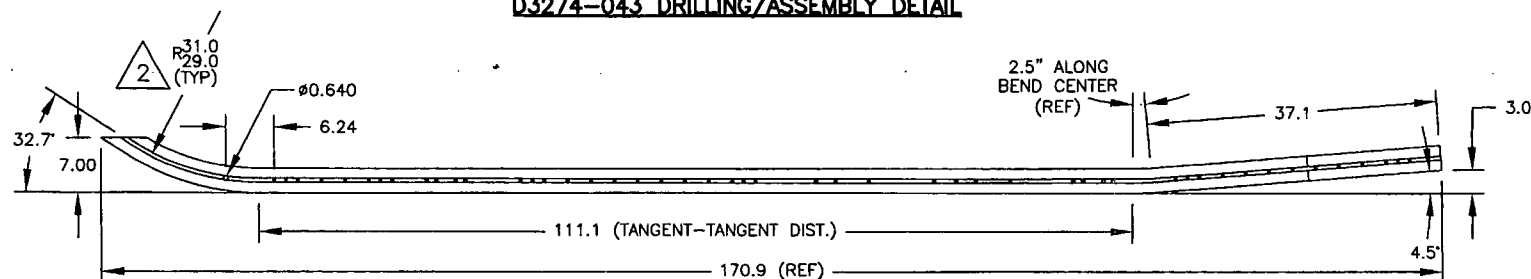
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

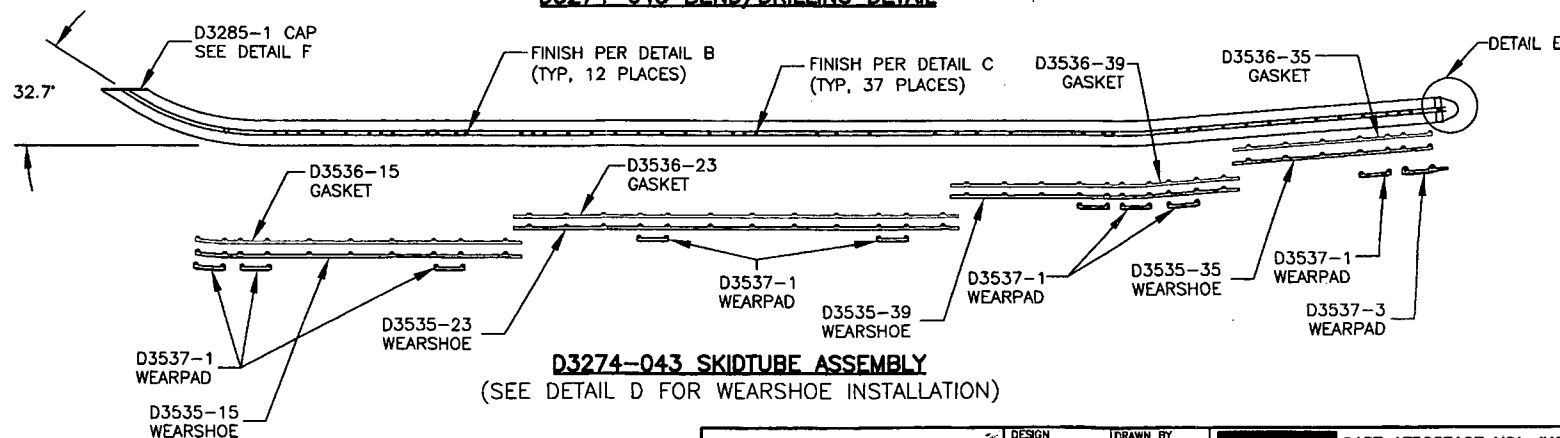
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

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CHECKED	CP	APPROVED	PH	DRAWING NO.	REV. D
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	D3274	SHEET 3 OF 4
				SCALE	1:15

5000

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

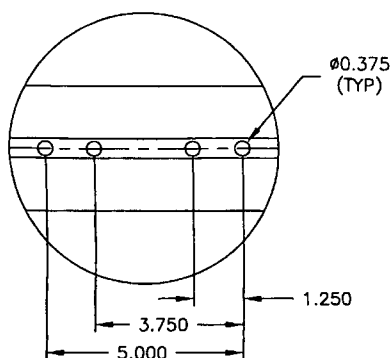
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

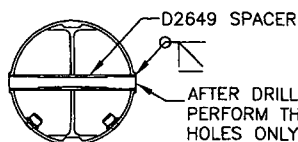
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DETAIL A: DRILL DETAIL

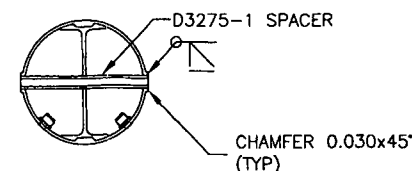


DETAIL B FOR Ø0.375 HOLES ONLY

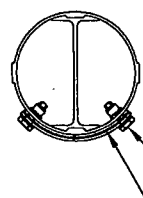


- AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C FOR Ø0.313 HOLES ONLY

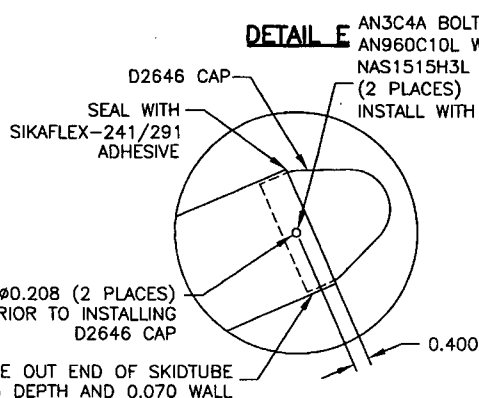


DETAIL D

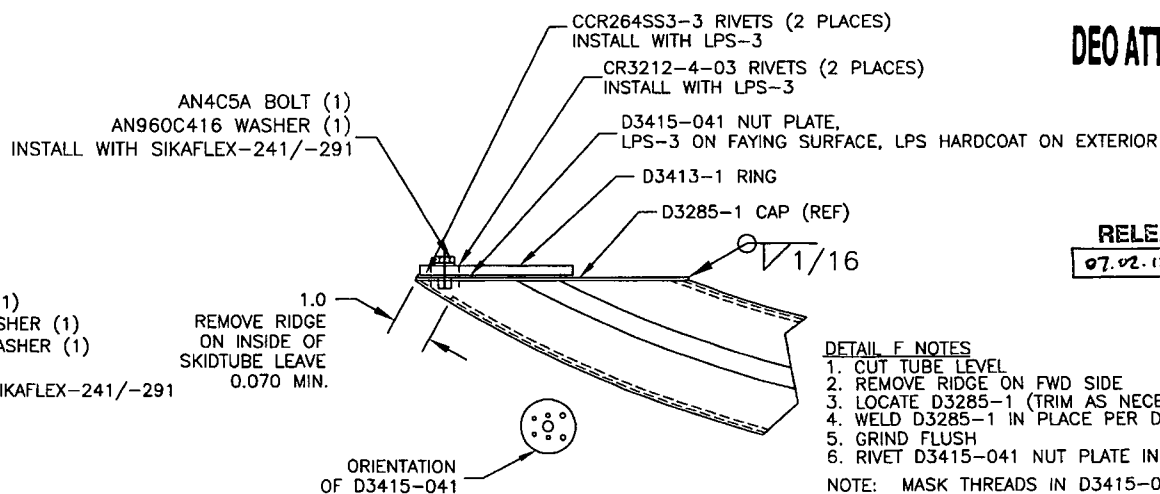


- ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E



DETAIL F: END FINISHING DETAIL



- DETAIL F NOTES**
1. CUT TUBE LEVEL
 2. REMOVE RIDGE ON FWD SIDE
 3. LOCATE D3285-1 (TRIM AS NECESSARY)
 4. WELD D3285-1 IN PLACE PER DART QSI 004
 5. GRIND FLUSH
 6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041 PRIOR TO FINISH

DEO ATTACHED

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07.02.12

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DESIGN	CP	DRAWN BY	PH	DART DART AEROSPACE USA, INC. PORT HADLOCK, MA
CHECKED	#	APPROVED	#	DRAWING NO. D3274
DATE	06.12.19	TITLE	SKIDTUBE ASSEMBLY	REV. D SHEET 4 OF 4 SCALE 1:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

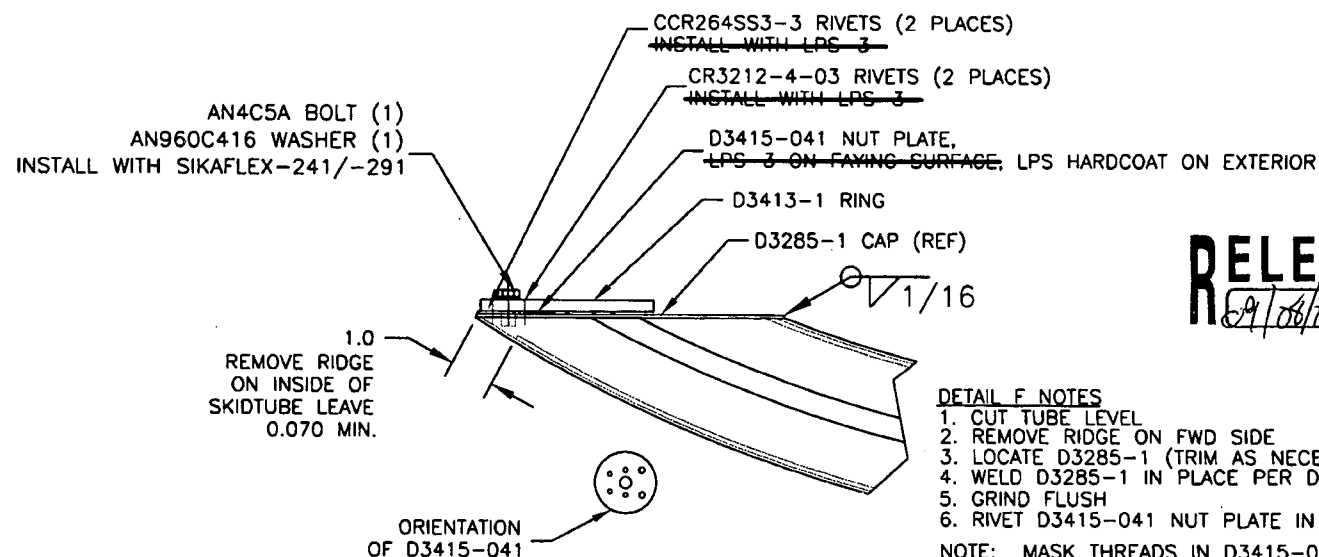
DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>UP</i>	CHECKED <i>L</i>	MFG. APPR. <i>M</i>	APPROVED <i>MAP</i>	DE APPR. <i>#</i>		
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE 09/06/23	DATE 09.06.23		

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: ~~"SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS 3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER."

AMEND DETAIL F AS SHOWN:

DETAIL F: END FINISHING DETAIL



DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D3285-1 (TRIM AS NECESSARY)
4. WELD D3285-1 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 201

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 47927A
Part number: D206 642 541
Description: float tube
Welding Process: Tig[☒] Mig[]
Base material: Aluminium
Current: AC[] DC[☒]

TEST REQUIREMENTS AND RESULTS

Visual:
Penetration:

pass[☒] fail[]
pass[☒] fail[]

UNACCEPTABLE

Cracks:
Undercut:
Pin holes:
Overlap (cold lap)
Porosity (surface):
Coloration:

pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]
pass[☒] fail[]

Qualifier Pat. Durr Date of Test Coupon 09-06-04
Welder Barclay Elliott Date of Test Coupon 09-06-04

The above named individual is qualified in accordance with AWS D17.1.2001 to weld